

Date: Thursday, 12/20/2007 3:20:05 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 36480	
Estimate Number : 10175	
P.O. Number : <i>N/A</i>	Part Number : D2570
This Issue : 12/20/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2570 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 36321	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 1/12/2008
Checked & Approved By : <i>[Signature]</i>	Qty: <i>650</i> Um: Each
Comment : Est E 02.08.29 Re-format; Removed finishing; Material changeK J est F 07.07.06 rev B dwg EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0750	303 Round Bar .75"
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Comment: Qty.: 0.0810 f(s)/Unit Total : 40.4775 f(s)
 Material: Ø0.750 AISI 303 SS Rod (M303R0.750)
 Batch *M106633*

*H.A. 08/01/06**J.F. 08/01/04*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 Machine as per folio FA198
 Deburr and ~~tumble~~ *[Signature]* *08-01-07*

*H.A. 08/01/06**J.F.*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. H.A. 08/01/06

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

[Signature] *08-01-07*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 42 (overstock)**AS 08/01/07**x650*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/01/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BUSHING

Job Number: 36480

Part Number: D2570

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



650

Comment: FINAL INSPECTION/W/O RELEASE

2008/01/08

Job Completion



2008/1/8

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 36480
Description: Bushing		Part Number: D2570
Inspection Dwg: D2570 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	.801"	✓			
0.060	+/-0.005	.062"	✓			
R0.010	+0.010/-0.000	R0.010"	✓			
Ø0.425	+0.000/-0.002	Ø.424	✓			
Ø0.257	+0.005/-0.000	Ø.257"	✓			
Ø0.750	+/-0.010	Ø.745"	✓			
0.030 x 20°	+/-0.010	0.028 x 20°	✓			

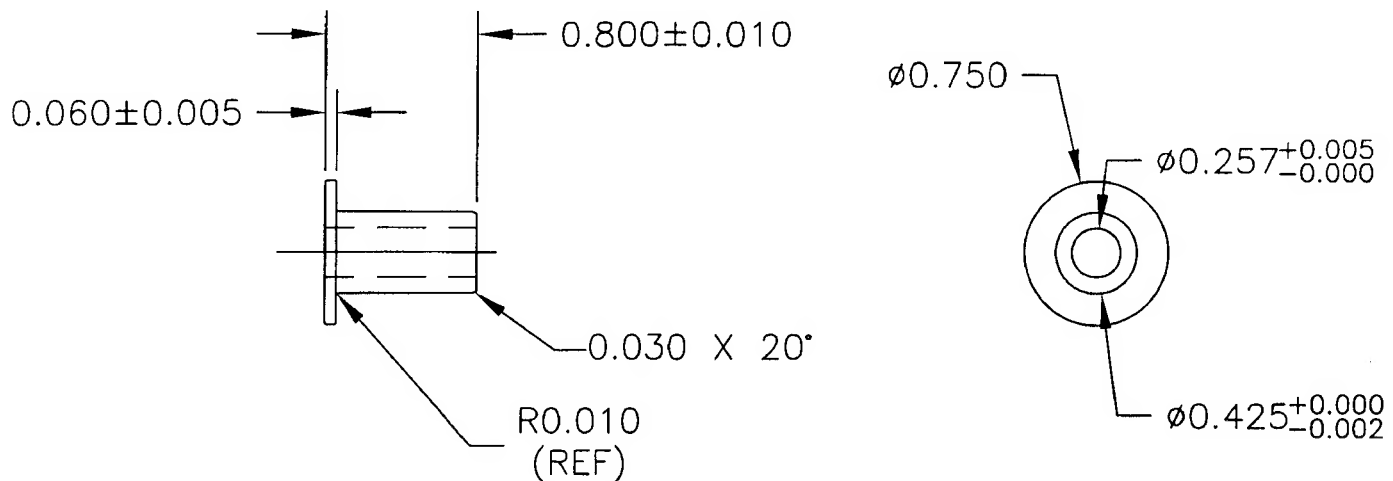
Measured by: J.F.	Audited by: S.P.	Prototype Approval:	N/A
Date: 08/01/04	Date: 08/01/04	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue	KJ/RF	
B	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
C	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM	EF



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2570	REV. B SHEET 1 OF 1
DATE 07.04.17		TITLE BUSHING	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	07.04.17	UPDATE NOTES	

RELEASED
07.06.28



D2570 BUSHING

D2570 BUSHING

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36480

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